

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69345

Monday, May 09, 2011 12:48:43 PM



Page 2

Item ID: DSI 9500-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI9500-011

Location: 20
PPP rev: DRAFT

11/5/9

20

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/9

MF

11-05-09

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Picklist Print

Monday, May 09, 2011 12:48:39 PM

Page 1

Work Order ID: 69345

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.01 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2731-7 Mounting Lug		Manufactured	No			110	Each	75.0000	2	4			
-------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST470	75	
61653	2	
62929	41	
66427	32	

D2732-030 Rubber Cushion		Manufactured	No			110	Each	12.0000	8	16			
-----------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
ST410	12	
56516	10	
65395	2	

D3394-043 Lug Assembly		Manufactured	No			110	Each	96.0000	2	4			
---------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST475	96	
62005	2	
62930	30	
62976	30	
66429	34	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, May 09, 2011 12:48:39 PM

Page 2

Work Order ID: 69345

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

D4064-041

Manufactured No

110

Each

31.0000

1



Mounting Lug



2
sl 11/5/9

Location

Loc Qty

Loc Code

ST462

18

62977

18

ST464

13

58980

12

58985

1

2

AN4C13A

Purchased No

110

Each

24.0000

4



BOLT



8
11/5/9

Location

Loc Qty

Loc Code

ST357

24

117619

24

AN4C14A

Purchased No

110

Each

78.0000

4



Bolt



8
sl 11/5/9

Location

Loc Qty

Loc Code

ST357

74

117366

40

117441

34

ST358

4

115767

4

AN4C15A

Purchased No

110

Each

95.0000

4



Bolt



4
4
11/5/9 sl (20)

Location

Loc Qty

Loc Code

ST358

95

115936

35

117441

60

8

Monday, May 09, 2011 12:48:40 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Monday, May 09, 2011 12:48:40 PM

Work Order ID: 69345

Parent Item: DSI 9500-011

Parent Item Name: Lug Upgrade Installation, 206 A/B Float Step

Start Date: 5/9/2011

Required Date: 5/9/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C416 NAS1149C0463 Purchased No

110

Each

0.0000

16

32

27x

5x

washer

AN960C416L

Purchased

No

110

Each

0.0000

8

16

WASHER

NAS1515H4L

Purchased

No

110

Each

508.0000

24

48

WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST266

20

114265

20

ST277

448

117363

448

MS21043-4

Purchased

No

110

Each

1,498.000

12

24

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

600

117423

600

ST301

858

114523

3

116188

55

116549

300

117601

500

3
21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-628 REV. F

REF FAA STC: SA00500SE

REF TCCA STC: SH98-14

REF EASA STC EASA.IM.R.S.01339

REFERENCE ONLY

PURPOSE:

UNMODIFIED D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 005 (OR EARLIER) WILL NOT INSTALL AT THE 18.50" HEIGHT REQUIRED FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS.

CHANGE:

D206-628-013/-014 STEP INSTALLATIONS AT CHANGE 006 (OR LATER) CONTAIN NEW MOUNTING LUGS FOR COMPATIBILITY WITH APICAL FLOATS.

CONTRARY TO INSTALLATION INSTRUCTIONS IIN-D206-628, FOR COMPATIBILITY WITH APICAL TRI-BAG FLOATS, THE D206-628-013/-014 STEP INSTALLATIONS SHOULD BE INSTALLED AT A HEIGHT OF 17.25" PER FIGURE 1 OF THIS SERVICE INSTRUCTION.

WHEN INSTALLING THE MOUNTING LUGS, IT IS ACCEPTABLE TO USE LONGER/SHORTER AN4C BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960C416/416L WASHERS UNDER THE BOLT HEADS TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

PARTS LIST OF SECTION 5.2 (PG. 12) OF IIN-D206-628-013/-014 REV. F IS AMENDED AS FOLLOWS:

QTY -013	QTY -014	QTY -023	QTY -024	QTY -033	QTY -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INSTALLATION, LH
	X					D206-628-014	206 A/B FLOAT STEP INSTALLATION, RH

WAS:

2	2					D2731-3	MOUNTING LUG
2	2					D2731-7	MOUNTING LUG
2	2					D3394-041	MOUNTING LUG
2	2					D3394-043	MOUNTING LUG
16	16					AN960C416L	WASHER

IS:

4	4					D2731-7	MOUNTING LUG
4	4					D3394-043	MOUNTING LUG
1	1					D4064-041	MOUNTING LUG (NEW)
1	1					*D4064-1	LUG
2	2					*MS35489-93	GROMMET
16	16					AN960C416	WASHER

* DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

A	NEW ISSUE	CP	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE USA, INC	
DRAWN	qp	PORT HADLOCK, WA	
CHECKED	3	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 1 OF 4
APPROVED	H	TITLE	SCALE
DE APPR.	H	MOUNTING LUG CHANGE	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

REFERENCE ONLY

THE DSI-9500-011 LUG UPGRADE KIT IS AVAILABLE TO UPDATE EXISTING D206-628-013/-014 STEPS TO CHANGE 006. THE UPGRADE KIT INCLUDES ADDITIONAL LUGS FOR STEPS INSTALLED WITH APICAL TRI-BAG FLOATS (AT 17.25" HEIGHT). EXISTING D206-628-013/-014 STEPS INSTALLED WITH OEM FLOATS (AT 15.00" HEIGHT) DO NOT REQUIRE THE KIT. THE UPGRADE KIT SHOULD BE INSTALLED PER THIS SERVICE INSTRUCTION AND IIN-D206-628 REV. F.

QTY	Part Number	Description
X	DSI-9500-011	LUG UPGRADE KIT, 206 A/B FLOAT STEP
2	D2731-7	MOUNTING LUG (REPLACES D2731-3 MOUNTING LUG)
8	D2732-030	RUBBER CUSHION
2	D3394-043	MOUNTING LUG (REPLACES D3394-041 MOUNTING LUG)
1	D4064-041	MOUNTING LUG (REPLACES ONE D3394-043 FOR APICAL TRI-BAG FLOAT COMPATIBLE INSTALL)
4	AN4C13A	BOLT
4	AN4C14A	BOLT
4	AN4C15A	BOLT
16	AN960C416	WASHER
8	AN960C416L	WASHER
24	NAS1515H4L	WASHER
12	MS21043-4	NUT

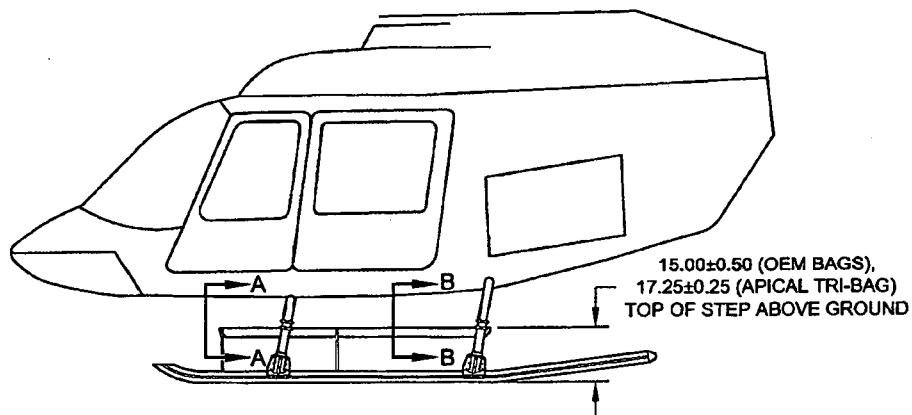
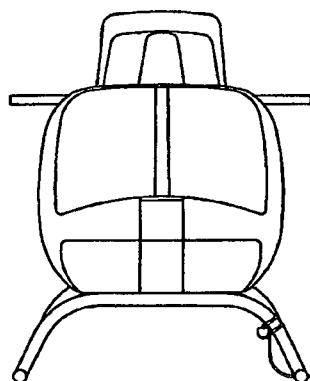
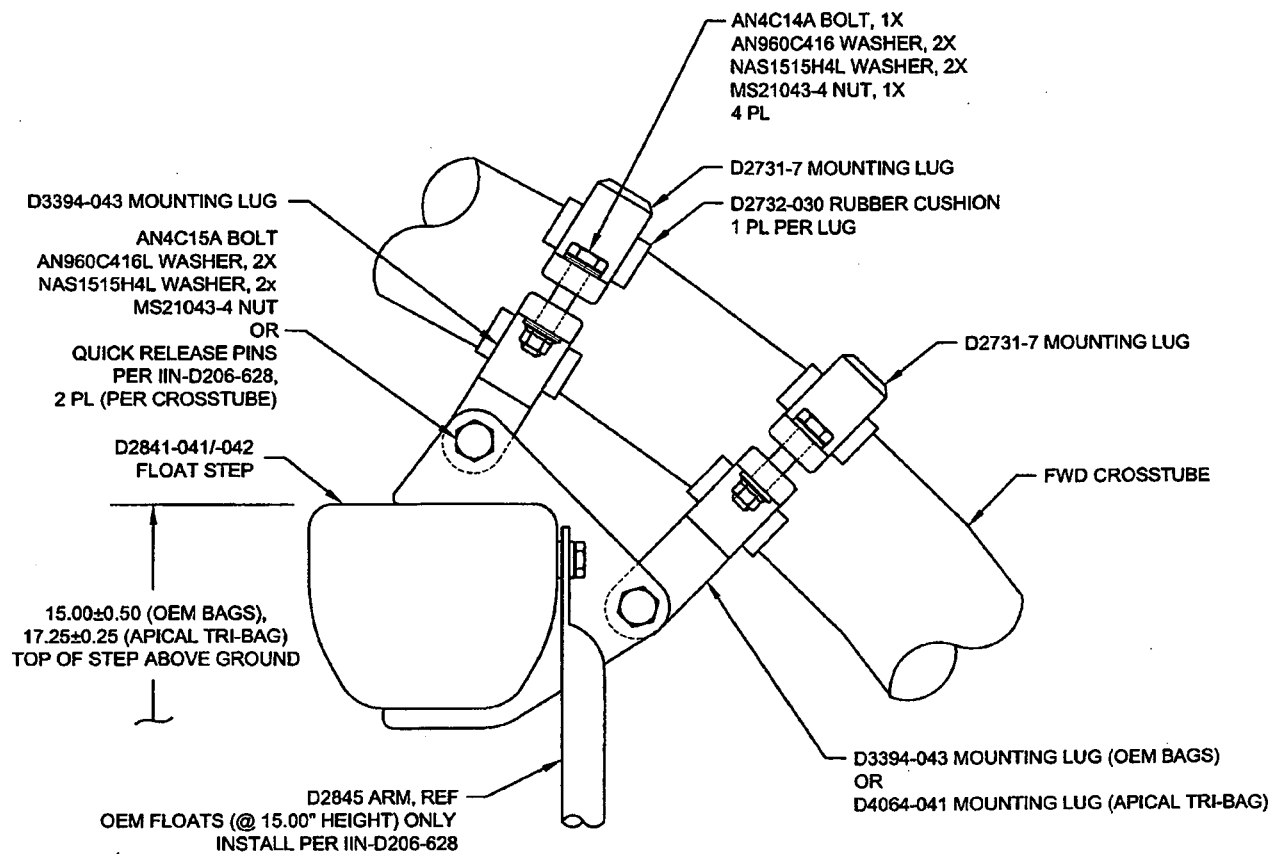


FIGURE 1
D206-628-013 (SHOWN) / -014 (OPPOSITE)
206 A/B FLOAT STEP INSTALLATION

DESIGN	99	DART AEROSPACE USA, INC
DRAWN	99	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9500 SHEET 2 OF 4
APPROVED		TITLE SCALE
DE APPR.		MOUNTING LUG CHANGE NTS
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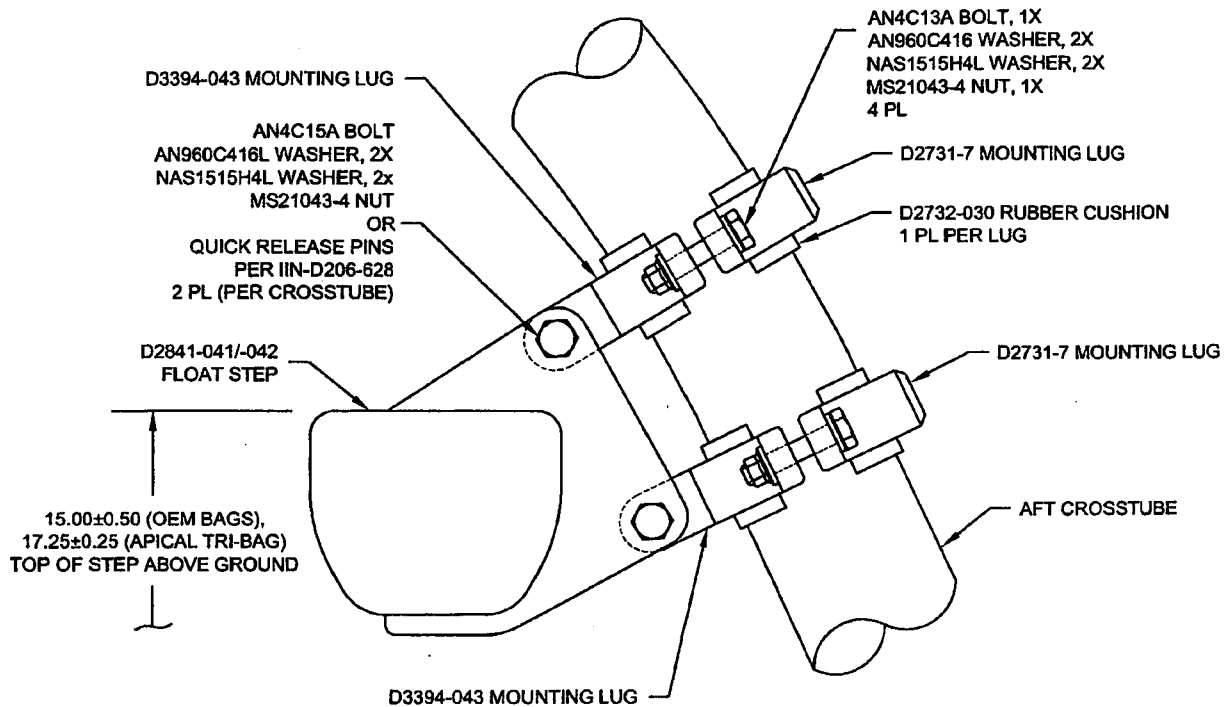
REFERENCE ONLY



SECTION A-A
FWD CROSSTUBE CLAMPING DETAIL

DESIGN	9P	DART AEROSPACE USA, INC	
DRAWN	9P	PORT HADLOCK, WA	
CHECKED	9P	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 3 OF 4
APPROVED	9P	TITLE	SCALE
DE APPR.	9P	MOUNTING LUG CHANGE	NTS
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REFERENCE ONLY



SECTION B-B AFT CROSSTUBE CLAMPING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9500	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG CHANGE	NTS
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